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| **CURRENT VERSION**  Change *Strikethrough* Text | **PROPOSED CHANGE**  Add or change Red text |
| **T-434.2.2 Block Thickness.** The block thickness  (*T*) shall be per Figure T-434.2.1.  **T-434.2.~~3~~ Alternate Block.** Alternatively, the  block may be constructed as shown in Nonmandatory  Appendix J, Figure J-431.  **III-434.2.3 Alternate Block.** The requirements of  T-434.2.~~3~~ are not applicable to the TOFD technique.  **T-434.4.1 Calibration Blocks for Technique One.**  The basic calibration block configuration and reflectors shall be as shown in Figure T-434.4.1. Either a side-drilled hole or flat bottom hole may be used. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base material shall be at least twice the thickness of the weld metal overlay cladding.  **T-434.4.2 Alternate Calibration Blocks for Technique**  **One.** Alternately, calibration blocks as shown in  Figure T-434.4.2.1 or Figure T-434.4.2.2 may be used.  The thickness of the weld metal overlay cladding shall  be at least as thick as that to be examined. The thickness of the base material shall be at least twice the thickness of the weld metal overlay cladding.  **T-434.4.3 Calibration Block for Technique Two.**  The basic calibration block configuration and reflectors shall be as shown in Figure T-434.4.3. A flat bottom hole drilled to the weld/base metal interface shall be used. This hole may be drilled from the base material or weld metal overlay cladding side. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base metal shall be within 1 in. (25 mm) of the calibration block thickness when the examination is performed from the base material  surface. The thickness of the base material on the calibration block shall be at least twice the thickness of  the weld metal overlay cladding when the examination  is performed from the weld metal overlay cladding  surface. | **T-434.2.2 Block Thickness.** The block thickness  (*T*) shall be per Figure T-434.2.1.  **T-434.2.3 Block Curvature.** The block curvature shall be in accordance with T-434.1.7.  **T-434.2.4 Alternate Block.** Alternatively, the  block may be constructed as shown in Nonmandatory  Appendix J, Figure J-431.  **III-434.2.3 Alternate Block.** The requirements of  T-434.2.4 are not applicable to the TOFD technique.  **T-434.4.1 Calibration Blocks for Technique One.**   1. The basic calibration block configuration and reflectors shall be as shown in Figure T-434.4.1. Either a side-drilled hole or flat bottom hole may be used. 2. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base material shall be at least twice the thickness of the weld metal overlay cladding.   The block curvature shall be in accordance with T-434.1.7.  **T-434.4.2 Alternate Calibration Blocks for Technique**  **One.**   1. Alternately, calibration blocks as shown in Figure T-434.4.2.1 or Figure T-434.4.2.2 may be used. 2. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base material shall be at least twice the thickness of the weld metal overlay cladding.   The block curvature shall be in accordance with T-434.1.7.  **T-434.4.3 Calibration Block for Technique Two.**   1. The basic calibration block configuration and reflectors shall be as shown in Figure T-434.4.3. A flat bottom hole drilled to the weld/base metal interface shall be used. This hole may be drilled from the base material or weld metal overlay cladding side. 2. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base metal shall be within 1 in. (25 mm) of the calibration block thickness when the examination is performed from the base material surface. The thickness of the base material on the calibration block shall be at least twice the thickness of the weld metal overlay cladding when the examination is performed from the weld metal overlay cladding surface.   The block curvature shall be in accordance with T-434.1.7. |